

Work Order ID 53263

October 29, 2009 11:45:09 AM



Page 1

Item ID: D2596

Accept



Setup Start



Revision ID: D

Stop



Item Name: Web, 205 Skidtube

Start Date: 29/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 09/10/29 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Draw Nbr	Revision Nbr
D2596	Rev D

100



Skidtubes

0.00

Skidtubes

Memo

0.00

1- Cut D2500-3-100 to length: 99.5" □ 2- Use Jig DT8093 to drill pilot holes
#30 □ 3- Open to 0.630" diameter as per Dwg D2596 □ 4- Deburr

9-11-4

5

110



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

S - - ALM 9.11.05

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

→ Saludos

(X5) 4 -

Picklist Print

Page 1

October 29, 2009 11:45:17 AM

Work Order ID: 53263



Parent Item: D2596RevD



Parent Item Name: Web, 205 Skidtube

Start Date: 29/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-3-100RevU/R		Manufactured	No		100		Each	0.0000	5.0000			

Ext'n ~T Beam Web 4"



B90196

5



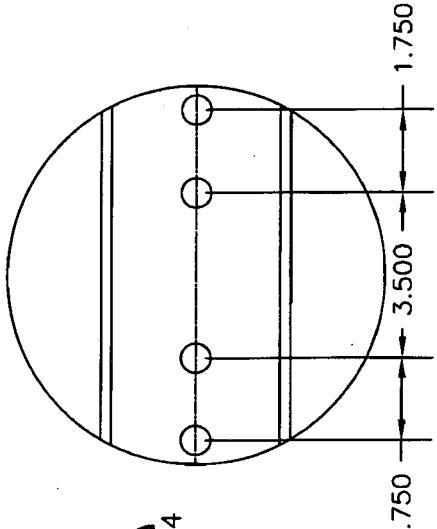
DP 9-11-4

DART

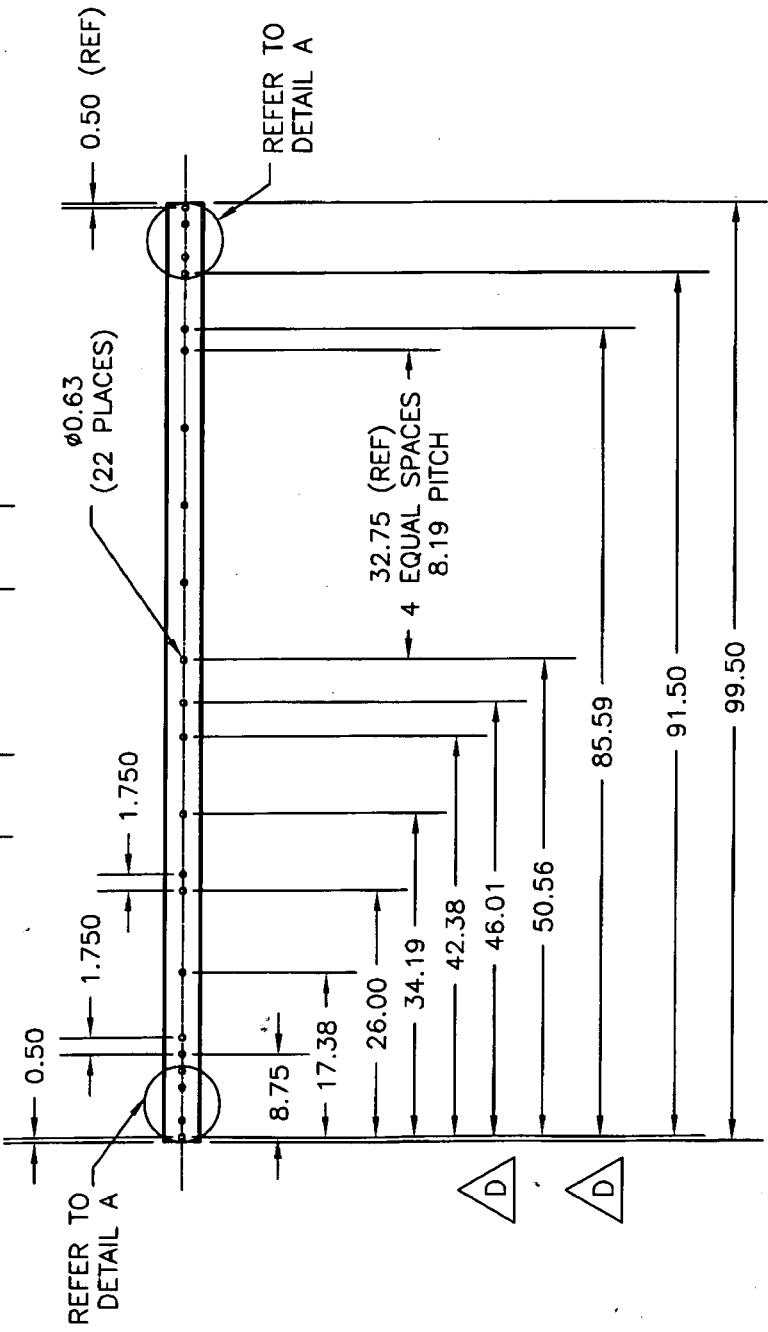
DESIGN <i>RH</i>	DRAWN BY <i>GH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED
07.06.08

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53263
PL09-10-29



DETAIL A
SCALE 1:4

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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